

Thursday, 10/11/2007 2:51:32 PM
Kim Johnston

Process Sheet

SPIT

45

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER INSTALLATION
Job Number	: 35112	Part Number	: D205706013
Estimate Number	: 12188	Drawing Number	: N/A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 10/11/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 11/6/2007
Previous Run	: 34215	Qty:	4 Um: Each
Written By	: <u>07.10.11</u>		
Checked & Approved By	: <u>07.10.11</u>		
Comment	: Est Rev: E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

10 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-706-013CHG001

20 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2001-4	Valve Assembly	B34235

AS 07/12/07

40 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3262-041	Canister Assembly	B33065

AS 07/12/07

50 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3264-1	Bracket	B32201

AS 07/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 35112

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D329710121 HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch
1 D3297-1-0121 Hose Assembly

B320226 x1 B32289

AS 07/12/07 (X1) (X3)

7.0 D329710130 HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch
1 D3297-1-0130 Hose Assembly

B329207 x1 B34244 x2

AS 07/12/07 (X1) (X3)

8.0 D329730350 HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch
1 D3297-3-0350 Hose Assembly

B322290

AS 07/12/07 (X1) (X3)

9.0 D3298001 Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch
1 D3298-001 Tube Assembly

B322046 x2 B323298

AS 07/12/07 (X1) (X3)

10.0 D3298009 Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch
1 D3298-009 Tube Assembly

B322202 x1 B33068 x2

AS 07/12/07 (X1) (X3)

11.0 D32991 Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch
1 D3299-1 Fitting

B320834 (X1) (X2)

(X1) (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D205706013

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

B29560

AS 07/12/07

(X)

(X)

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

Doubler

B23304

AS 07/12/07

(X)

(X)

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

B23305

AS 07/12/07

(X)

(X)

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

B33069 (x2)

AS 07/12/07

(X)

(X)

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

B29943 (x1)

AS 07/12/07

(X)

(X)

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M100188

AS 07/12/07

(X)

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description:

18.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17710

AS 07/12/07 (TL) (KS)

19.0

AN8156D

Union-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M17054

AS 07/12/07 (TL) (KS)

20.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M103691

AS 07/12/07 (TL) (KS)

21.0

AN9246D

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M104374

AS 07/12/07 (TL) (KS)

22.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M105792

AS 07/12/07 (TL) (KS)

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

M104374

AS 07/12/07 (TL) (KS)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description:

4 AN960JD10L

Washer

24.0

AN960JD916

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

M100857

AS 07/12/07

(H)

(X)

25.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M105558

AS 07/12/07

(H)

(X)

26.0

MS21919WDG9

Clamp



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

M103044

AS 07/12/07

(H)

(X)

27.0

MS21919WDG12

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

1 MS21919WDG12

Clamp

M101925

AS 07/12/07

(H)

(X)

28.0

MS21919WDG16

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

2 MS21919WDG16

Clamp

M101925(x1)

M105970(x5)

AS 07/12/07

(H)

(X)

29.0

MS21920-42

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18048

AS 07/12/07

(H)

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 8/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35112

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

M104885

AS 07/12/07

✓

ⓧ

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M16323

AS 07/12/07

✓

ⓧ

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 07/12/07

ⓧ

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev: B

AS 7/12/07

ⓧ

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/12/07

ⓧ

Job Completion



AS 07-12-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries